

Date: Monday, 1/8/2007 10:44:20 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STOP
Job Number	: 30139A		
Estimate Number	: 10731		
P.O. Number	: N/A	Part Number	: D23243
This Issue	: 1/8/2007	S.O. No.	: J1A
Prsht Rev.	: NC	Drawing Number	: D2324 REV. C
First Issue	: N/A	Project Number	: N/A
Previous Run	: 28914A	Drawing Revision	: C
Written By	:	Material	: N/A
Checked & Approved By	: <u>JF</u> 01.01.08	Due Date	: 1/20/2007 Qty: 20 Um: Each
Comment	: Est: E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 K J/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0750X00750	6061-T6 Bar .75" x .75"	
		Comment: Qty.: 0.5565 f(s)/Unit Total : 11.1300 f(s) 6061-T6 Bar 0.75" x 0.75" Material: 6061-T6/6511 (QQ-A-200/8) or (QQ-A-225/8) or 5052-H34 (QQ-A-225/7) or (QQ-A-250/8) (M6061T6B0.750x00.750) Batch: M102476	JF 07/02/27 22
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: (0.75" x 0.75") x 5.75" Long Bar	JF 07/02/27 22
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio D2324-3 and Dwg D2324 2- Deburr and Tumble to remove sharp edges Identify as D2324-3	MS 07/02/28
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	MS 07/02/28
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	EP 07/02/01 X22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/03/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 07/03/02

(22)

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

ml 07/03/02 x22

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G4

P 07/3/2

(20)

ml 07/03/02

x20

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

190703/05

(20)

Job Completion



U 6X03-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30139A
Description: Strut	Part Number:	D2324-3
Inspection Dwg: D2324	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

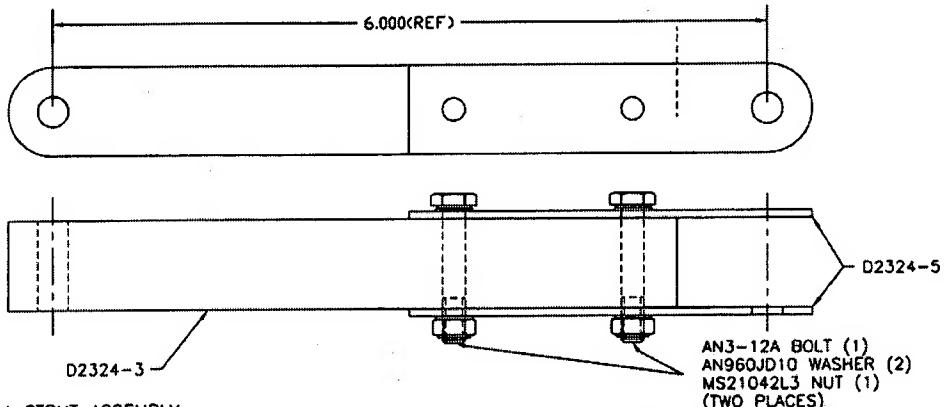
Measured by:	M8	Audited by:	<i>JNL</i>	Prototype Approval:	N/A
Date:	07/02/28	Date:	07/02/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.10	New Issue P/O D2324-1	KJ/JLM	
B	06.03.08	Dwg Rev changed	KJ/JLM	JL

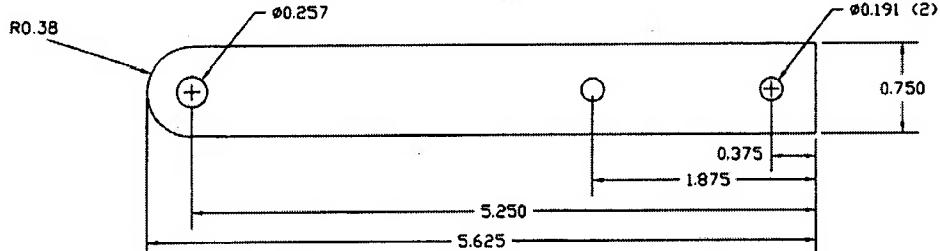
DART

DESIGN B. WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2324
DATE 04.12.14		REV. C SHEET 1 OF 1
		TITLE STRUT
A	94.11.08	SCALE NEW ISSUE
B	96.05.07	UPDATE MATERIALS
C	04.12.14	UPDATE NOTES

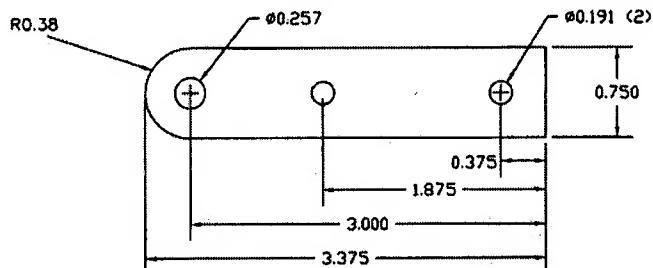
RELEASED

04.12.16 *[Signature]***D2324 STRUT ASSEMBLY**

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

**D2324-3**

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *30139A*